

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003436**Date Inspected:** 30-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 100**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wen Pang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe fabrication and perform Ultrasonic Testing (UT) of Orthotropic Box Girder (OBG) and Tower components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

**Tower Heavy Machinery Shop Bay # 2**

The Caltrans QA Inspector performed random UT verification of ZPMC Quality Control (QC) inspected and accepted Complete Joint penetration welds of East Tower Skin Plate "C". The QA Inspector performed UT verification of welds ESD1-SA77 A/E- 44, ESD1-SA77 - D/E 10 and 11, ESD1-SA77 - E/E 11 and 12 .The welds tested appeared to be in general conformance with AWS D1.5 table 6.3 and contract documents. See UT report TL-6027 generated on this date for further information.

**Sub Assembly Shop Bay # 8**

The Caltrans QA performed Ultrasonic Testing (UT) Verification of OBG Floor Beam web plate 30 mm to 12 mm CJP welds, FB079-001-032, FB007-007-026, FB042-001-032, FB001-007-026, FB078-001-032 and FB-007-008-026. Ultrasonic testing was performed from face "A" with a 70 degree transducer and evaluated in the first and second leg. The welds tested appeared to be in general conformance with AWS D1.5 table 6.3 and contract documents. See UT report TL-6027 generated on this date for further information.

**Sub Assembly Shop Bay # 7**

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## WELDING INSPECTION REPORT

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The Caltrans QA performed Ultrasonic Testing (UT) Verification of OBG Floor beam diaphragm 20 mm CJP welds, FB003-045-104, FB003-045-105 and FB003-025-105. Ultrasonic testing was performed from face "A" with a 70 degree transducer and evaluated in the first and second leg. The above mentioned welds were tested and accepted by ZPMC Quality Control (QC). The welds tested appeared to be in general conformance with AWS D1.5 table 6.3 and contract documents. See UT report TL-6027 generated on this date for further information.

### Summary of Conversations:

Only general conversations between Caltrans QA and QC occurred this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, 138 1694 2685, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	Lanz,Joe	QA Reviewer

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